

Work Order ID 151888***151888***

Page 1

Friday, October 14, 2016 1:38:26 PM

Item ID: D2804-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 10/14/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/17/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

Date:

OCT 14 2016

Tooling:

Date:

Run Start

NR1

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2804

D

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.05

FLOW CNC Waterjet

1-Cut as per File D2804-1-2_BLANK

Dwg Rev: D

Prog Rev: AA

CHECK WITH MACHINIST FOR DIRECTION OF MATERIAL
BOW/WRAPPAGE PRIOR TO CUTTING

2-Deburr if necessary

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.29

HAAS CNC vertical machine #1

Machine as per folio FA103

2

0

DAS

20

9-89

17-01-16

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Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Bracket

Start Date: 10/14/2016 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 10/17/2016 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

OC

Memo

0.00

Quality Control

121

0.00

121

Mill Conv

Memo

0.00

Conventional Milling Machine

COUNTERSINK BACK SIDE AS PER DWG

122

QC2- Inspect parts off machine FAI/FAIB

0.00

122

QC

Memo

0.00

Quality Control

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151888

Page 3

Item ID: D2804-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 10/14/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 10/17/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01		17-01-10		2	0		DAS 08 9-89
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.09				(x2)	0		2017/01/11 BEB
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				2			DAS 38 JAN 11 2017

Work Order ID 151888

Friday, October 14, 2016 1:38:26 PM

151888

Page 4

Item ID: D2804-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 10/14/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/17/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: **8475**

0.00

160

Packaging

Memo

0.00

2

JAN 13 2017

**DAS
6
9-89**

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.03

RA

JAN 15 2017

Quality Control

mf**17-1-13**

Picklist Print

Page 1

Friday, October 14, 2016 1:38:31 PM

Work Order ID: 151888

151888

Parent Item: D2804-2

D2804-2

Parent Item Name: Bracket

Start Date: 10/14/2016

Required Date: 10/17/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A00.11.06New IssueEC
IPP B06.05.30 Blanks on wtjetEC
IPP Rev:C As per Rev C 06-11-09 JLM
IPP Rev:D Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X12.00 0		Purchased	No				f	4.0300		2.8			

M6061T6B0 500X12.0000

6061-T6 Bar .500 x 12.00

see 10/10/14

AK

Location

Loc Qty

Loc Code

MAT

2.2

m131392

2.2

MAT001

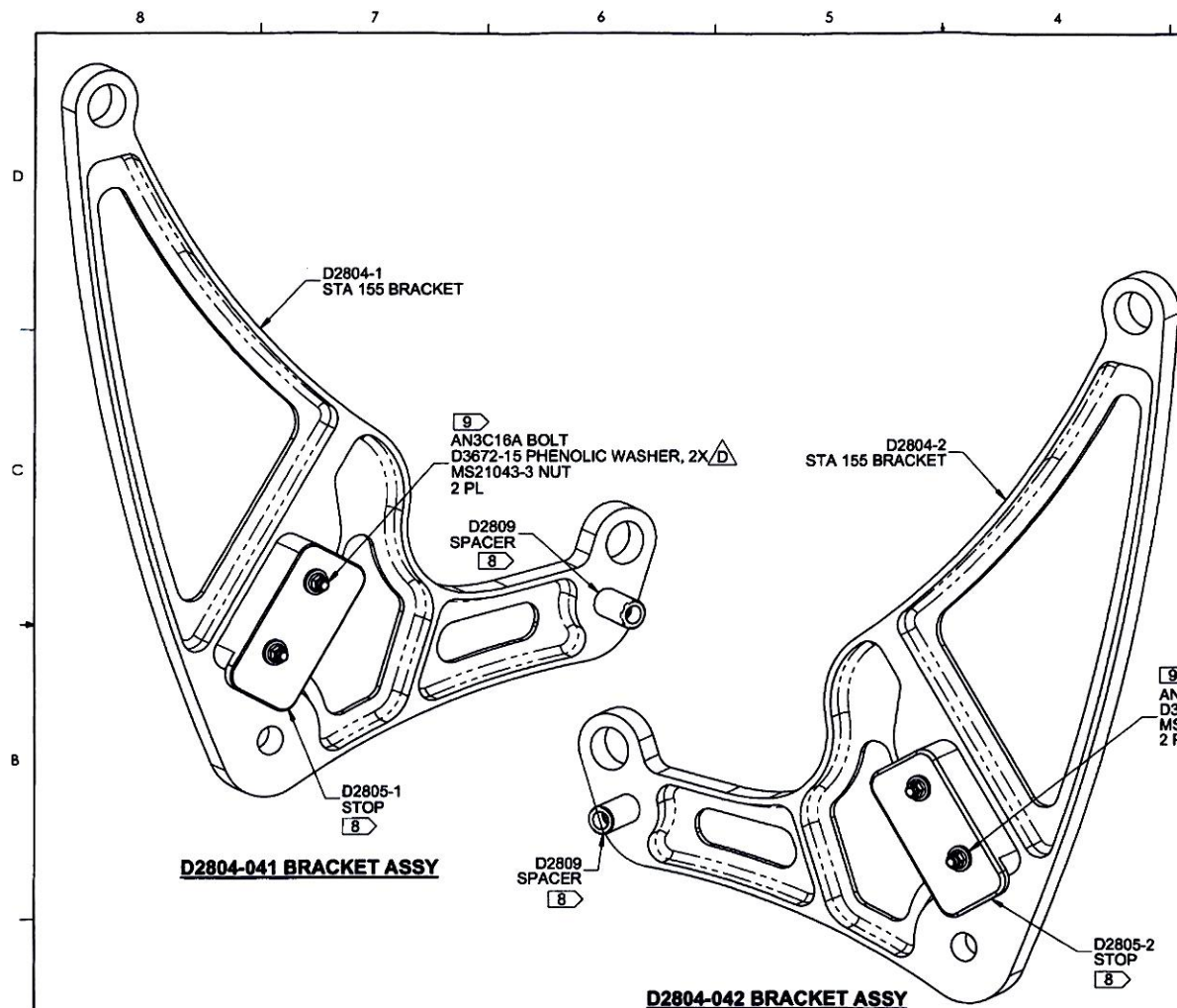
1.83

m128866

1.83

135512

3



ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D2804-041	BRACKET ASSY
		X	D2804-042	BRACKET ASSY
1	1		D2804-1	STA 155 BRACKET
2		1	D2804-2	STA 155 BRACKET
3	1		D2805-1	STOP
4		1	D2805-2	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151888 MJS
16-10-14

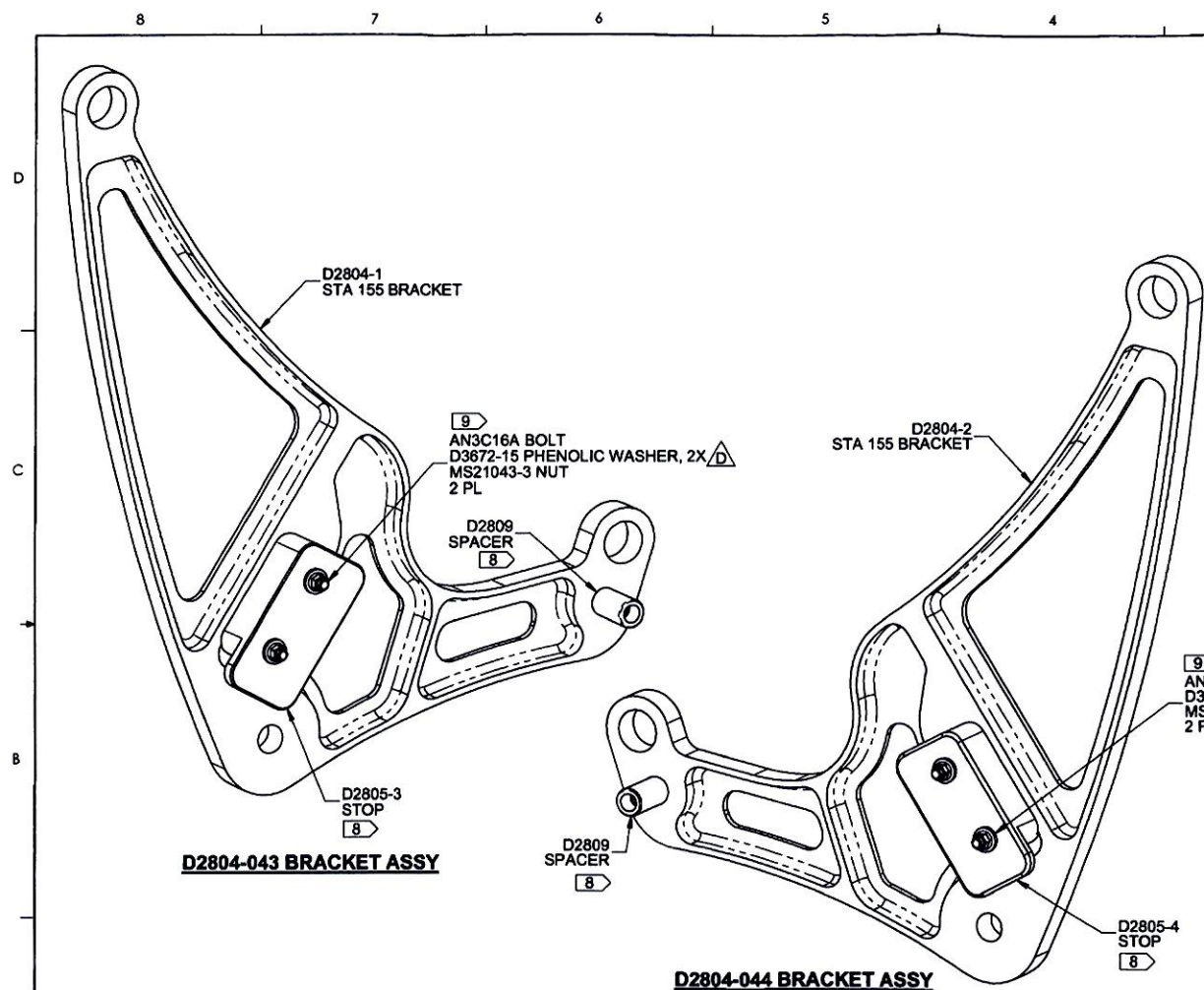
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2016 JUN 22
ECN 16-661

D	REVISE TO CURRENT FORMAT; D3672-15 WAS NAS1515H3; MS21043-3 WAS MS21042-3; ADD CSINK (SECTIONS E-E AND J-J). REF: PAR16-499. D6-31-4: 2.656 WAS 2.654 REASON: CAD ERROR.	MB	16.04.11
C	CHANGE GEOMETRY TO ADD CLEARANCE	CP	06.10.16
B	ADD CUTOUTS AND -043/-044	CP	04.11.22
A	NEW ISSUE	CP	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2804	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STA 155 BRACKET	NTS
DATE	16.04.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) OR "GREY SANDEX" (4.3.5.6) OR "BLACK SANDEX" (4.3.5.7) OR "GREEN SANDEX" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 1.37 lbs
 - 8) PRESS D2805-X AND D2809 INTO PLACE PRIOR TO POWDER COAT
 - 9) INSTALL BOLT WITH LPS-3 CORROSION INHIBITOR, ENSURE NO LPS-3 ON THREADS



ITEM	QTY -043	QTY -044	P/N	DESCRIPTION
	X		D2804-043	BRACKET ASSY
		X	D2804-044	BRACKET ASSY
1	1		D2804-1	STA 155 BRACKET
2		1	D2804-2	STA 155 BRACKET
3	1		D2805-3	STOP
4		1	D2805-4	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING

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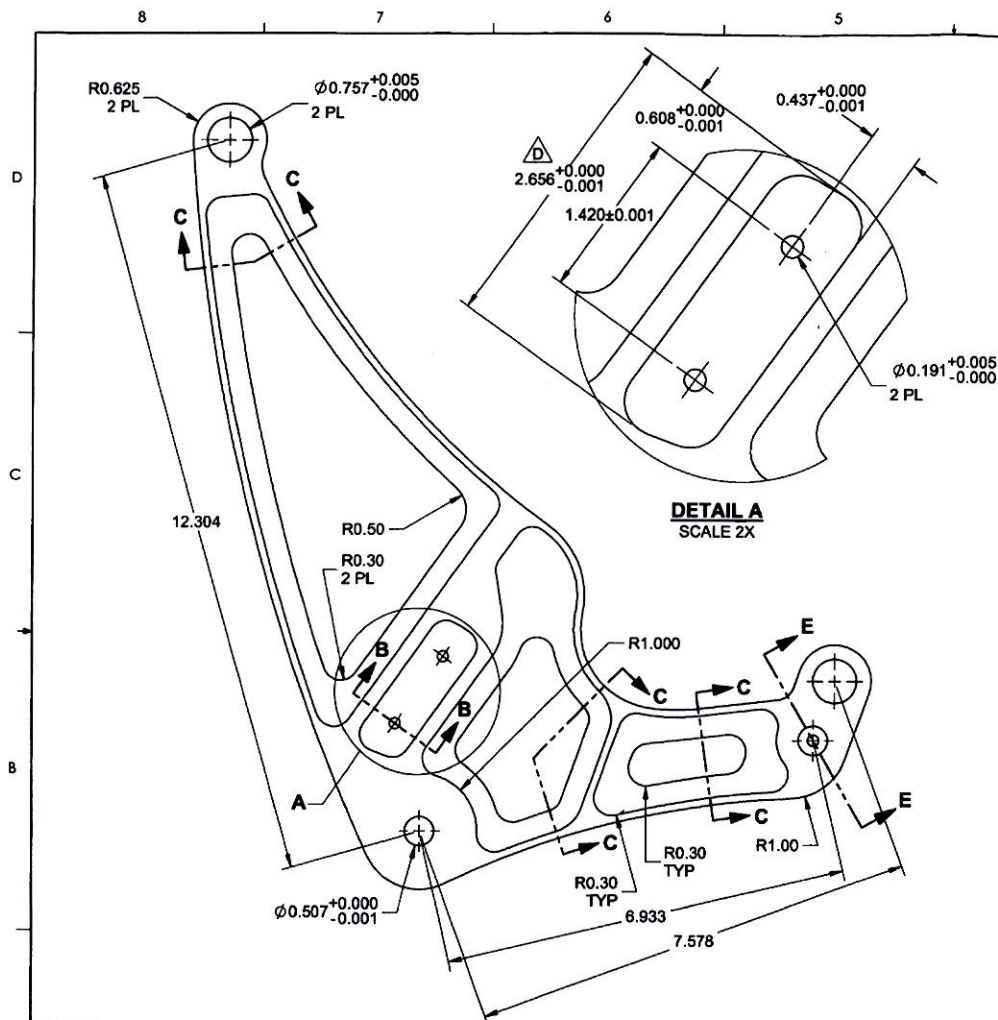
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) OR "GREY SANDTEX" (4.3.5.6) OR "BLACK SANDTEX" (4.3.5.7) OR "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 1.37 lbs
- 8) PRESS D2805-X AND D2809 INTO PLACE PRIOR TO POWDER COAT
- 9) INSTALL BOLT WITH LPS-3 CORROSION INHIBITOR, ENSURE NO LPS-3 ON THREADS

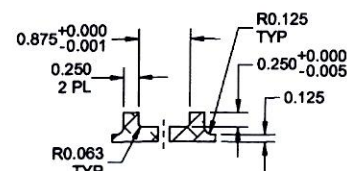
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2016 JUN 22 *qp*

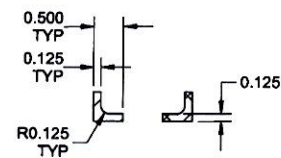
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	CHECKED	ML	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D2804	SHEET 2 OF 4
	APPROVED	WM	TITLE	SCALE
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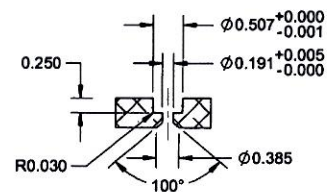
DETAIL A
SCALE 2X



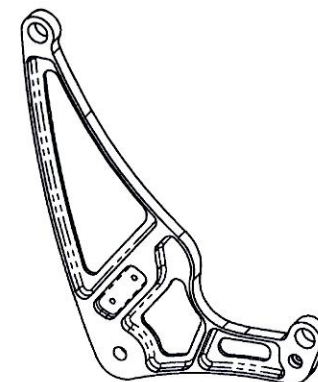
SECTION B-B
(ROTATED)



SECTION C-C
(ROTATED)



SECTION E-E
(ROTATED)



D2804-1 STA 155 BRACKET

NOTES:

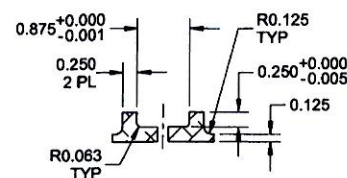
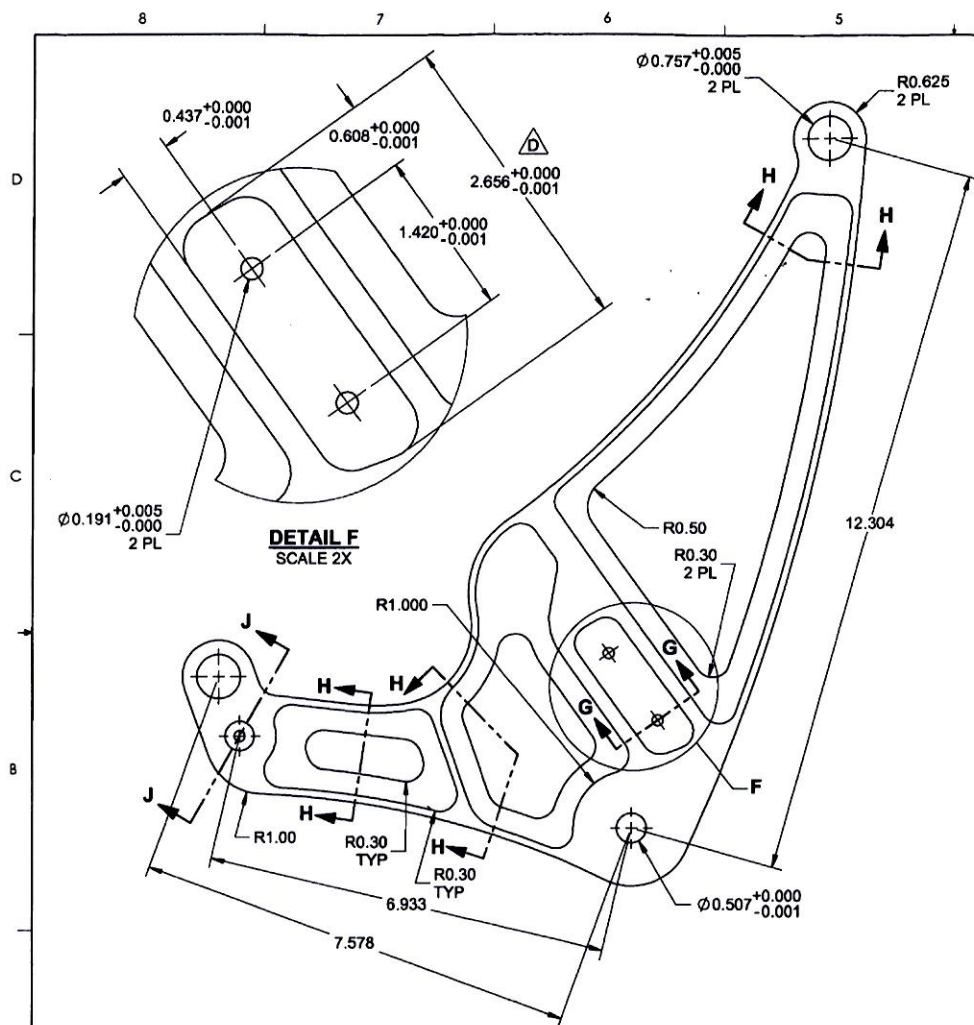
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: R0.030 TO 0.063 ON ALL EDGES
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.01 lbs
- 8) MACHINE PER PART FILE D2804-1_REV.D.SLDPR

APPROVED

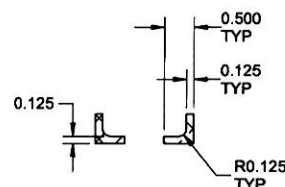
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2804	SHEET 3 OF 4
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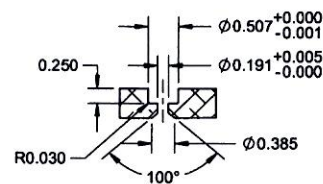
2016 JUN 22 09



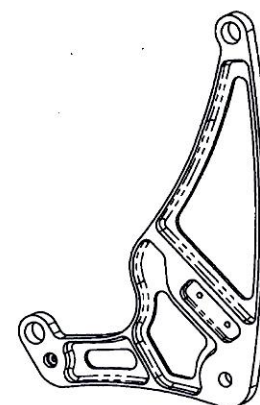
SECTION G-G
(ROTATED)



SECTION H-H
(ROTATED)



SECTION J-J
(ROTATED)



D2804-2 STA 155 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: R0.030 TO 0.063 ON ALL EDGES
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.01 lbs
- 8) MACHINE PER PART FILE D2804-1_REV.D.SLDPRT

RELEASED

2016 JUN 22 *q*

APPROVED	DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	MB		
	CHECKED	ML	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D2804	SHEET 4 OF 4
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	STA 155 BRACKET	NTS
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